

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007624**Date Inspected:** 19-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG and Tower Fabrication**Summary of Items Observed:**

CWI Inspector: Mr. Shen Fu You

On this date CALTRANS OSM Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. The QA Inspector observed the following:

Prior to Caltrans QA Inspectors' concurring with issuance of OBG deck plate closed rib green tag releases a review of the ultrasonic inspection database is performed to verify all closed rib tack weld repair locations have been ultrasonically accepted. Today this QA Inspector, Mr. Paul Dawson, performed data entry of ultrasonic inspection information from the field generated Ultrasonic inspection data sheets onto the common drive computer database for the following OBG deck panels: DP156-001, DP181-001, DP236-001, DP237-001, DP262-001 and DP312-001.

Tower Bay 14

The QA Inspector observed ZPMC welder Ms. Gao Min, stencil 050988 is using flux cored welding procedure WPS-B-T-2233-B-U2-F to make weld SEG-047 between OBG deck plate DP094-001 and DP121-001. The QA Inspector observed a welding current of approximately 290 amps, 29.5 volts and QC personnel were monitoring this welding. Items observed on this date appeared to generally comply with applicable contract documents.

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The QA Inspector observed ZPMC welder Mr Li Jiao, stencil 049861 is using the shielded metal arc welding procedure WPS-B-T-2112 to make tack weld SEG-048*-004 between OBG deck plate DP481-001 and DP391-001. The QA Inspector observed a welding current of approximately 130 amps and QC personnel were monitoring this welding. The welding electrodes are being stored in a portable heated oven. Items observed on this date appeared to generally comply with applicable contract documents. Note: the “*” in the segment number indicates this is a top segment plate.

The QA Inspector observed ZPMC welder Mr. Ge Hao, stencil 201583 is using flux cored welding procedure WPS-B-T-2233-TC-04-B-F to make weld SSD13-BP59-004. The QA Inspector observed a welding current of approximately 230 amps, 24.0 volts and QC personnel were monitoring this welding. Items observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

See above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 150-0042-2372 , who represents the Office of Structural Materials for your project.

Inspected By:	Dawson,Paul	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
